37

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET
Job Number	: 34281		
Estimate Number	: 10854		
P.O. Number	:	Part Number	: D350721041
This Issue	: 8/28/2007 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 33904	Material	:
Written By	:	Due Date	: 9/14/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.08.28		
Comment	: Est Rev:D as per Rev B 05-11-21 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D350-721-041CHG002 07/08/28 07.08.30

2.0	34281A	BASKET LID ASSEMBLY

Comment: Sub-Component BASKET LID ASSEMBLY
D3325-041 B 34281 A 07/09/10

3.0	34281B	BASKET BASE ASSEMBLY

Comment: Sub-Component BASKET BASE ASSEMBLY
D3324-041 B 34281 B 07/09/10

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assembly Kit

5.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	B30543

07/09/10

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET

Job Number: 34281 **Part Number:** D350721041

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

6.0 D2332041 Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D2332-041	prop arm	B32572

7.0 D2530 Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Weldment
Batch: B32573

8.0 D2535 Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2535	Spring	B31486

9.0 D2537 Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2537	Bushing	B32574

10.0 D2931 Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	B21139

11.0 D3320041 Webbing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3320-041	Webbing	B32586

07/09/10

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET

Job Number: 34281
Part Number: D350721041

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D33511	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3351-1	Label	B33784

Seq. #:	Machine Or Operation:	Description :
13.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M104093

Seq. #:	Machine Or Operation:	Description :
14.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	AN4-7A	Bolt	M102140

Seq. #:	Machine Or Operation:	Description :
15.0	AN420A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	AN4-20A	Bolt	M16895

Seq. #:	Machine Or Operation:	Description :
16.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M102959

Seq. #:	Machine Or Operation:	Description :
17.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M104885

07/09/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET

Job Number: 34281 **Part Number:** D350721041

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	AN960JD416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
2 AN960JD416 Washer ~~44746~~ M104746

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD416L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M105078

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M104156

Seq. #:	Machine Or Operation:	Description :
21.0	AN960JD8	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M104374

Seq. #:	Machine Or Operation:	Description :
22.0	AN960JD9	Washer

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
32 AN960JD9 Washer M105399

Seq. #:	Machine Or Operation:	Description :
23.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assembly Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

07/09/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET

Job Number: 34281 **Part Number:** D350721041

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
32	MS20600AD4W3	Rivet	M104715

Seq. #:	Machine Or Operation:	Description :
25.0	MS20600AD4W2	Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	MS20600AD4W2	Rivet	M4747

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	MS21042L3	Nut (or -3)	M104936

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
4	MS21042L4	Nut (or -4)	M104248

Seq. #:	Machine Or Operation:	Description :
28.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assembly Kit

Qty	Part Number	Description	Batch
4	MS21042L5	Nut (or -5)	M104547

07/09/10

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ___________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** HELI UTILITY BASKET

Job Number: 34281 | **Part Number:** D350721041

Job Number:

Seq. #:	Machine Or Operation:	Description :
29.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

P10

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg IIN-D350-721Attach Travelers:
Seal rivet Holes with Sika Flex before riveting
A/R 291 Sika Flex Batch: M104732
Exp Date: 10/2007

ML 07/09/12

30.0	QC5.	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

ER 07/09/12

31.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

32.0	D22301	Mounting Lug

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
3	D2230-1	Lug	B32163

33.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-3	Clamp	B30993

34.0	D2856400	Abrasion Strip

Comment: Qty.: 2.5200 f(s)/Unit Total : 2.5200 f(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2856-4007.20"	Abrasion Strip	B25656

07/09/12

Form: rprocess

Dart Aerospace Ltd

W/O:		**WORK ORDER CHANGES**					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D350-721-041 **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR: 34281		**WORK ORDER NON-CONFORMANCE (NCR)**						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
07-09-10	290	The D3367-1 mounting brackets were welded @ 36.5" apart instead of 34.5", on both base and lid. R.C: Human error, & missed dimension upon inspection. On the moon!!	QS1042	-remove the D3367-1 bracket, and Scrap/Replace B34207 Qty ② -Weld in position as per Dwg ~~re-do inspection QC9/5~~ -Re-powder coat D3324-041 & D3325-041 per QS1005	PD 07-09-10 07/09/10 AJ 07-9-11	07/09/11 ~~09/09/11~~ ~~AQS1042~~	QS1042	07-09-10

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET

Job Number: 34281
Part Number: D350721041

Job Number:

Seq. #:	Machine Or Operation:	Description :
35.0	D33381	Mounting Lug

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3338-1	Lug	B33248

Seq. #:	Machine Or Operation:	Description :
36.0	D3350041	Strut Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3350-041	Strut	B34487

Seq. #:	Machine Or Operation:	Description :
37.0	AN412A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4-12A	Bolt	M105143

Seq. #:	Machine Or Operation:	Description :
38.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-13A	Bolt	M104746

Seq. #:	Machine Or Operation:	Description :
39.0	AN414A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN4-14A	Bolt	M102473

07/09/12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET

Job Number: 34281
Part Number: D350721041

Job Number:

Seq. #:	Machine Or Operation:	Description :
40.0	AN960JD416	Washer

Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
28	AN960JD416	Washer	M104746

Seq. #:	Machine Or Operation:	Description :
41.0	MS21042L4	Nut

Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
18	MS21042L4	Nut (or -4)	M104248

07/09/20

Seq. #:	Machine Or Operation:	Description :
42.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

07/09/28

Seq. #:	Machine Or Operation:	Description :
43.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-721-041
Location:__________
PPP Rev: C

7/5/28 (1)

Seq. #:	Machine Or Operation:	Description :
44.0	QC21	FINAL INSPECTION/W/O RELEASE

07.10.01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

07.10.01

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.

37

Date: Tuesday, 8/28/2007 7:52:46 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 34281A		
Estimate Number	: 10853		
P.O. Number	:	Part Number	: D3325041
This Issue	: 8/28/2007 S.O. No. :	Drawing Number	: D3325 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 33904A	Material	:
Written By	:	Due Date	: 9/14/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.08.28		
Comment	: Est Rev:A 05.02.09 New issue KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D33281	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3328-1	Hinge Plate	B24123

PD 07-08-29

Seq. #:	Machine Or Operation:	Description :
2.0	D33491	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3349-1	Spacer Bushing	B32588

PD 07-08-29

Seq. #:	Machine Or Operation:	Description :
3.0	D33521	Label Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3352-1	Label Plate	B23110

PD 07-08-29

Seq. #:	Machine Or Operation:	Description :
4.0	D33671	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3367-1	Mounting Bracket	B31207

PD 07-08-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

Job Number: 34281A **Part Number:** D3325041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	M4130NTS0500W035	4130 Square tube .5 x .5

Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)
PD 07-08-29

Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	M97679
3	D3325-3	Interior Tube	
2	D3325-5	Full Lengh Tube	

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
A/RN/ASteel Rod M100075

4-Deburr as required
PD 07-08-29

Seq. #:	Machine Or Operation:	Description :
7.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION
07/09/04

Seq. #:	Machine Or Operation:	Description :
8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
07/09/04

Seq. #:	Machine Or Operation:	Description :
9.0	POWDER COATING	POWDER COATING

M 105068 M105068 07-09-10

Comment: POWDER COATING , Repowdercoat NCR
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 BK 07-09-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 34281A

Part Number: D3325041

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION ml 07/09/10

Seq. #:	Machine Or Operation:	Description :
11.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA
ml 07/09/10

Seq. #:	Machine Or Operation:	Description :
12.0	QC21	FINAL INSPECTION/W/O RELEASE

07.10.01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

8-10-01

Dart Aerospace Ltd

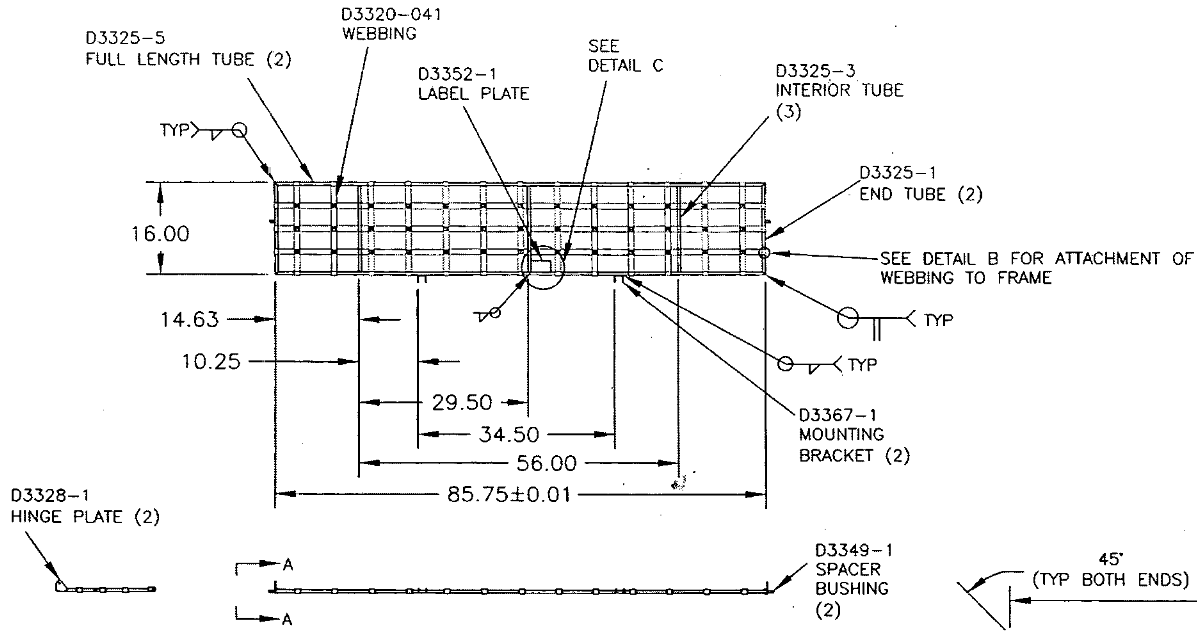
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

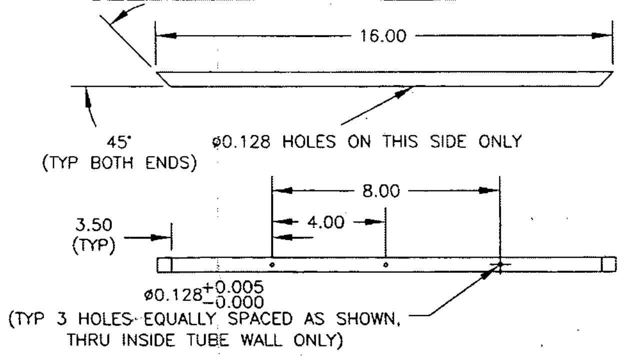
Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

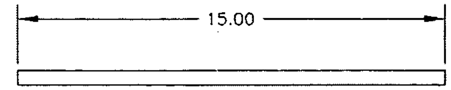
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

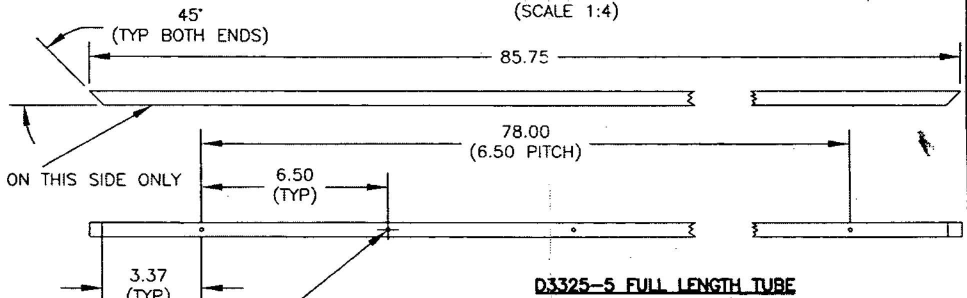




D3325-1 END TUBE
(SCALE 1:4)



D3325-3 INTERIOR TUBE
(SCALE 1:4)



ø0.128 +0.005 −0.000
(TYP 13 HOLES, EQUALLY SPACED,
THRU INSIDE TUBE WALL ONLY)

D3325-5 FULL LENGTH TUBE
(NOT TO SCALE)

D3325-041 BASKET LID ASSEMBLY

1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
   (PRIOR TO INSTALLATION OF D3320-041)
2) WELD PER DART QSI 004
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3325-1/-3/-5

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035
   (REF. DART SPEC M4130N-TS0.500W.035)
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN960JD9	32	WASHER

RELEASED 05.04.28

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NO. 3428 / A

REV	DATE	DESCRIPTION
B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE

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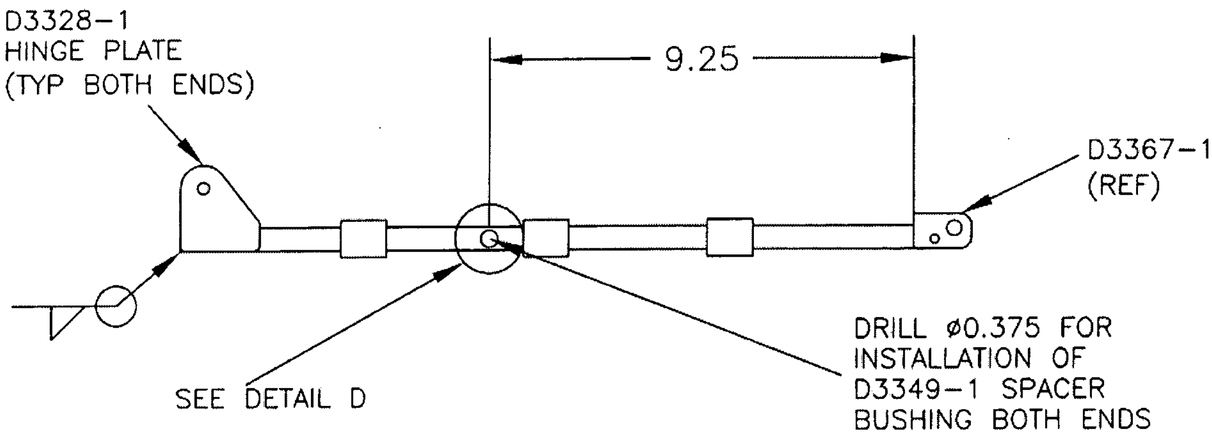
DESIGN: DH | DRAWN BY: PH | CHECKED | APPROVED
DATE: 05.04.25

DART — DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA

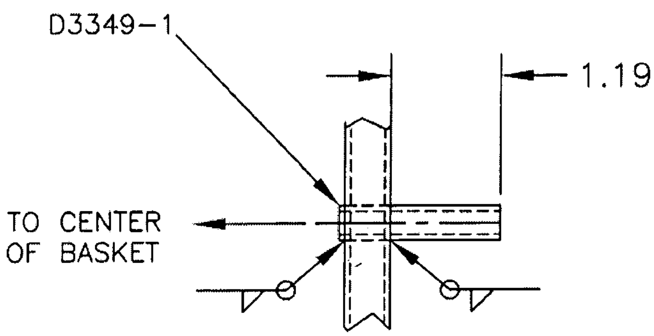
DRAWING NO. D3325 | REV. B | SHEET 1 OF 3
TITLE: BASKET LID ASSEMBLY | SCALE 1:20

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D
(SCALE 1:2)

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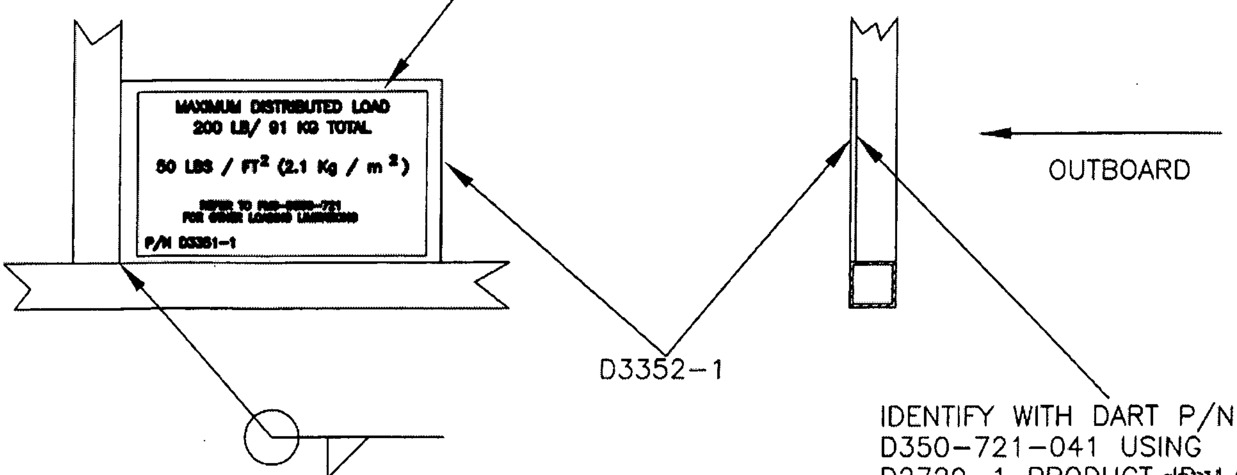
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CHECKED	APPROVED	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID FRAME
(SCALE 1:1)

RELEASED 05.04.28



IDENTIFY WITH DART P/N D350-721-041 USING D2729-1 PRODUCT ID LABEL INSTALLED ON UNDERSIDE OF D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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37

Date: Tuesday, 8/28/2007 7:52:56 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY
Job Number	: 34281B		
Estimate Number	: 10852		
P.O. Number	:	Part Number	: D3324041
This Issue	: 8/28/2007 S.O. No. :	Drawing Number	: D3324 ~~UNDER REVIEW~~ OK PH 07.08.28
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 33904B	Material	:
Written By	:	Due Date	: 9/14/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.08.28		
Comment	: Est Rev.A 05.02.09 New issue KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D33283	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3328-3	Hinge Plate	B34124

PD 07-09-04

Seq. #:	Machine Or Operation:	Description :
2.0	D33481	Clevis

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3348-1	Clevis	B32848

PD 07-09-04

Seq. #:	Machine Or Operation:	Description :
3.0	D33493	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3349-3	Spacer Bushing	B32589

PD 07-09-04

Seq. #:	Machine Or Operation:	Description :
4.0	D33671	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3367-1	Mounting Bracket	B34207

PD 07-09-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY

Job Number: 34281B **Part Number:** D3324041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	M4130NTS0500W035	4130 Square tube .5 x .5

Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)
104695 PD 07-09-04

Seq. #:	Machine Or Operation:	Description :
6.0	M569EX05018F	569 Expanded Metal

Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)
Pick:
Qty Part Number Description Batch
28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel M105261 PD 07-09-04

Seq. #:	Machine Or Operation:	Description :
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	M104695
4	D3324-3	Full Length Tube	
2	D3324-5	Top End Tube	
2	D3324-7	Bottom EndTube	
10	D3324-9	Vertical Tube	

Identify parts appropriately

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B
A/RN/ASteel Rod M100015

4-Deburr as required PD 07-09-04

Seq. #:	Machine Or Operation:	Description :
8.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/09/04

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 7:52:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET BASE ASSEMBLY

Job Number: 34281B
Part Number: D3324041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   07/09/04

10.0	POWDER COATING	POWDER COATING

M 105068   M105068

Comment: POWDER COATING   Repowdercoat as per NCR 07-09-11
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3   BK 07-09-04

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   ml 07/09/10

12.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: G4   ml 07/09/10

13.0	QC21	FINAL INSPECTION/W/O RELEASE

07.10.01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion   07.10.01

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

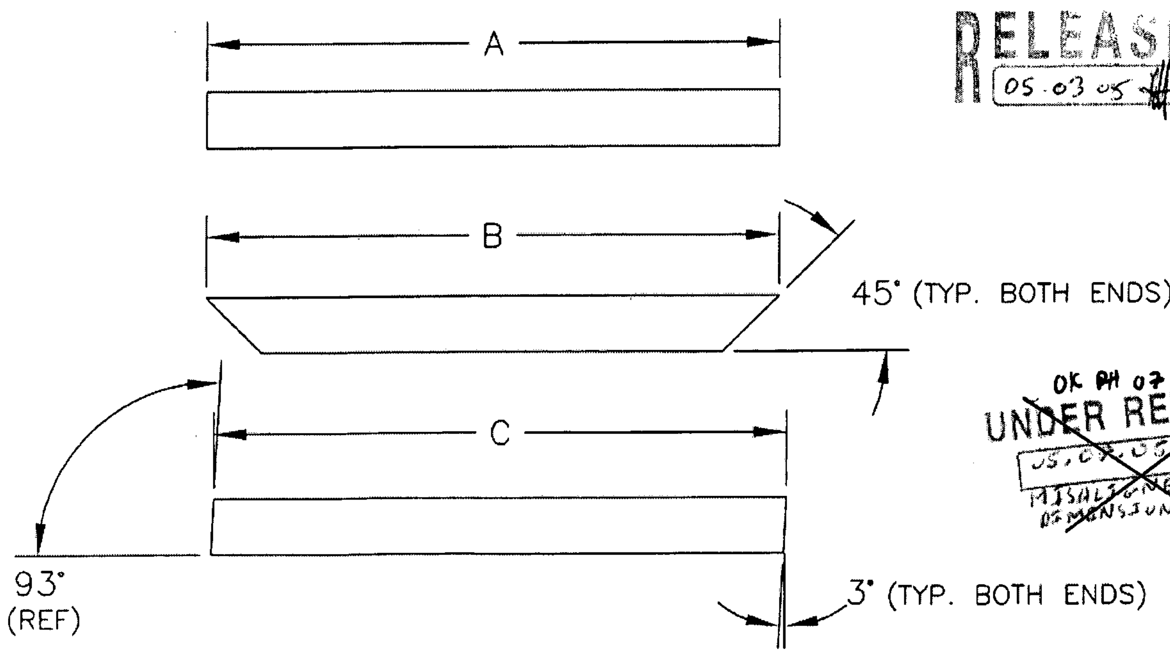
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [signature]	APPROVED [signature]	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS

A	04.10.20	NEW ISSUE
B	05.03.04	UPDATE MESH MATERIAL SPEC

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

RELEASED 05.03.05



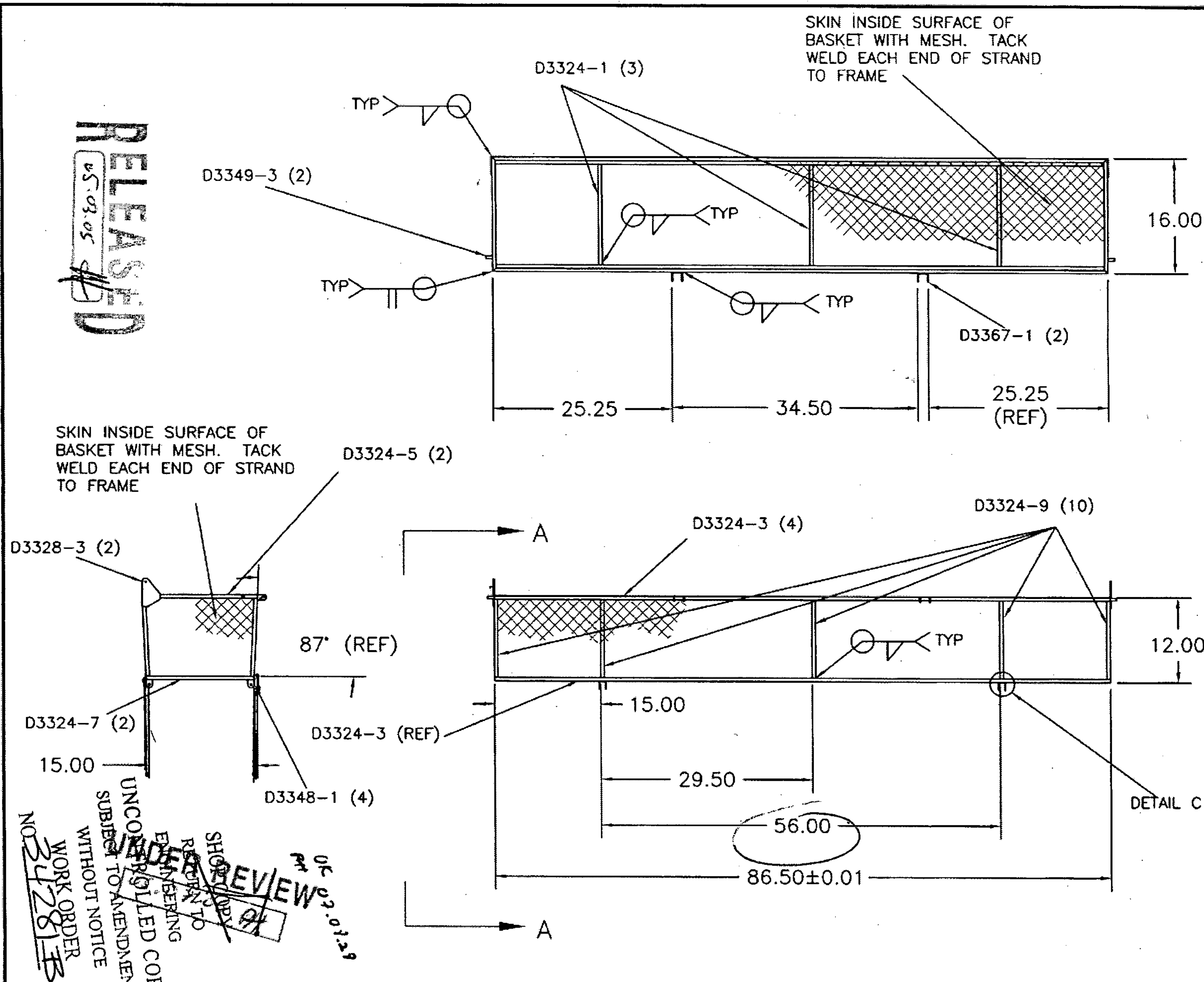
OK PH 07.08.28
UNDER REVIEW 05.07.05 PH
MISALIGNED DIMENSION PG 2

D3324-1/-3/-5/-7/-9

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. X 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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D3324-04T BASKET BASE ASSEMBLY

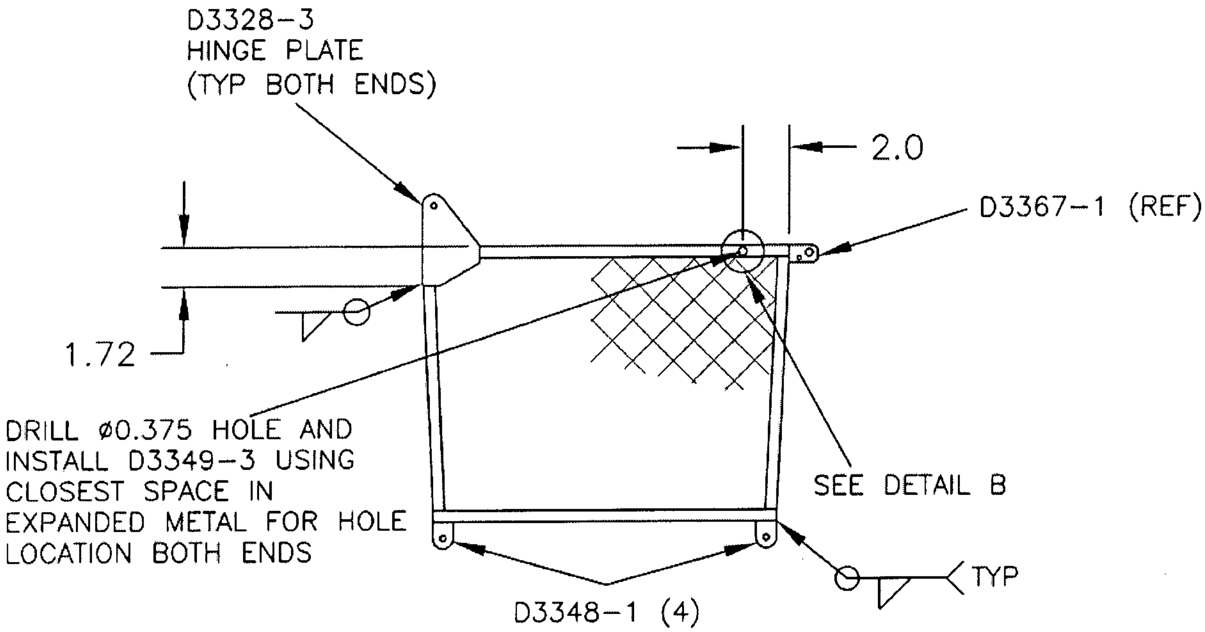
1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
2) WELD PER DART QSI 004
3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DRAWING NO.	DART AEROSPACE LTD
CHECKED	APPROVED	D3324	HAWKESBURY, ONTARIO, CANADA
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:20

DART

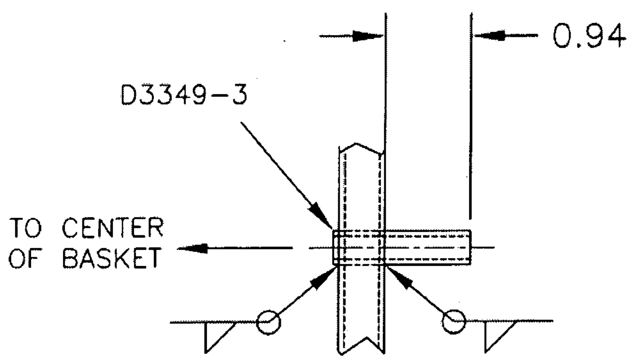
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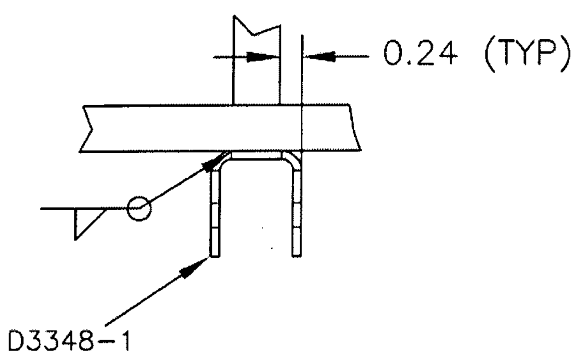
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DATE 05.03.04		TITLE BASKET BASE ASSEMBLY SCALE 1:8



VIEW A-A

RELEASED 05.03.05





DETAIL B
(SCALE 1:2)

DETAIL C
(SCALE 1:2)

UNDER REVIEW 05.07.06 PH
OK PH 07.08.23

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